

Date: Friday, 18/07/2008 1:10:20 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CABIN FLOOR PROTECTOR		
Job Number	: 40647			Part Number	: D35744		
Estimate Number	: 12765			Drawing Number	: D3574 REV.A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/07/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 31/07/2008 Qty: 2 Um: Each		
Previous Run	: 35865						
Written By	:						
Checked & Approved By	: <u>JUL 08-7-18</u>						
Comment	: Est Rev :A New Issue 07-01-22 EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
Comment: Qty.: 33.6000 sf(s)/Unit Total : 67.2000 sf(s) lexan sheet Batch: <u>10S330</u> <u>HB 8-7-22</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: <u>A</u> <u>HB 8-7-22</u> <span style="margin-left: 100px;">(2)</span> Prog Rev: <u>A</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 <u>HB 8-7-22</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 <span style="margin-left: 100px;">(1)</span>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 <span style="margin-left: 100px;">(2)</span>		
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Deburr if necessary. <u>SAD 08/07/08</u> <span style="margin-left: 100px;">(2)</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 40647

Part Number: D35744

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/07/28 (2)*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *RRPW632*

*08/07/28 (2)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/29 (2)*

Job Completion



*MF 08-07-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>40047</u>
Description: Cabin Floor Protector	Part Number:	D3574-4
Inspection Dwg: D3574	Rev: A	Page 1 of 3

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+0.004/-0.001	1.19	*			<i>Type measure</i>
Ø3.00	+0.006/-0.001	3.03	*			
1.25	+/-0.030	1.25	*			
7.62	+/-0.030	7.62	*			
10.25	+/-0.030	10.25	*			
11.87	+/-0.030	11.87	*			
14.75	+/-0.030	14.75	*			
26.00	+/-0.030	26.00	*			
34.13	+/-0.030	34.13	*			
40.87	+/-0.030	40.87	*			
45.00	+/-0.030	45.00	*			
48.00	+/-0.030	48.00	*			
55.13	+/-0.030	55.13	*			
59.50	+/-0.030	59.50	*			
59.75	+/-0.030	59.75	*			
61.25	+/-0.030	61.25	*			
61.88	+/-0.030	61.88	*			
64.63	+/-0.030	64.63	*			
2.00	+/-0.030	2.00	*			
7.38	+/-0.030	7.38	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
17.62	+/-0.030	17.62	*			
25.87	+/-0.030	25.87	*			
34.25	+/-0.030	34.25	*			
34.94	+/-0.030	34.94	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			<i>Not checked</i>
51.00	+/-0.030	51.00	*			

*08/19/03*

DART AEROSPACE LTD	Work Order:	40067
Description: Cabin Floor Protector	Part Number:	D3574-4
Inspection Dwg: D3574 Rev: A		Page 2 of 3

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
58.38	+/-0.030	58.38	*			100%
61.25	+/-0.030	61.25	*			
63.43	+/-0.030	63.43	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
1.13	+/-0.030	1.13	*			
3.13	+/-0.030	3.13	*			
7.63	+/-0.030	7.63	*			
8.13	+/-0.030	8.13	*			
11.00	+/-0.030	11.00	*			
14.50	+/-0.030	14.50	*			
15.75	+/-0.030	15.75	*			
18.40	+/-0.030	18.40	*			
22.10	+/-0.030	22.10	*			
22.50	+/-0.030	22.50	*			
24.50	+/-0.030	24.50	*			
25.50	+/-0.030	25.50	*			
30.75	+/-0.030	30.75	*			
34.00	+/-0.030	34.00	*			
35.13	+/-0.030	35.13	*			
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	40.00	*			
41.50	+/-0.030	41.50	*			
41.88	+/-0.030	41.88	*			
43.63	+/-0.030	43.63	*			
44.70	+/-0.030	44.70	*			
3.70	+/-0.030	3.70	*			
6.06	+/-0.030	6.06				

DART AEROSPACE LTD	Work Order:	40047
Description: Cabin Floor Protector	Part Number:	D3574-4
Inspection Dwg: D3574	Rev: A	Page 3 of 3

# FIRST ARTICLE INSPECTION CHECKLIST

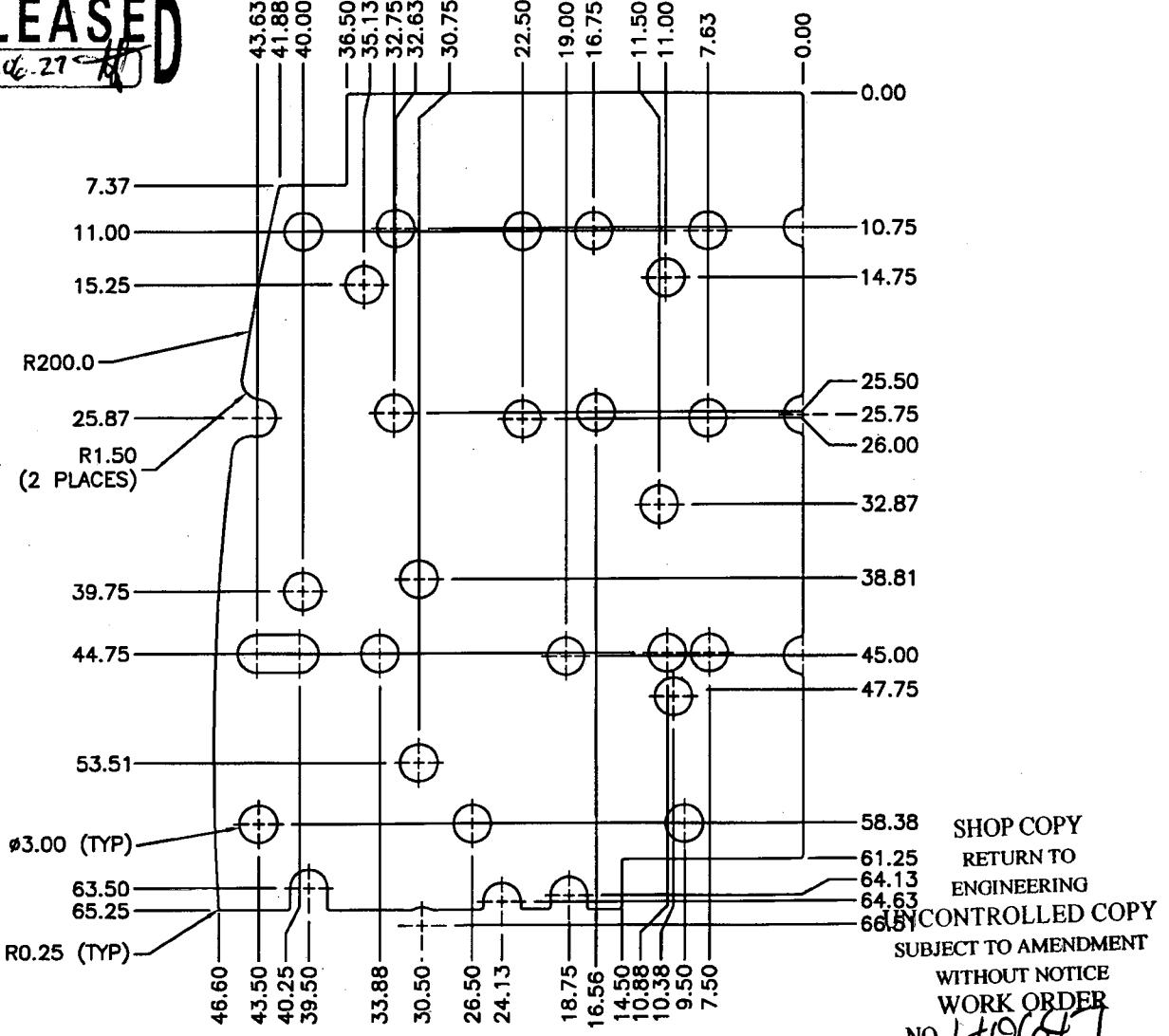
## X First Article      Prototype

Measured by: <u>AB</u>	Audited by: <u>D</u>	Prototype Approval: N/A
Date: 08-07-23	Date: 08/07/23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ//DD	

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>HT</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
	A	07.06.08	NEW ISSUE

**RELEASED**  
*07.06.27***D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

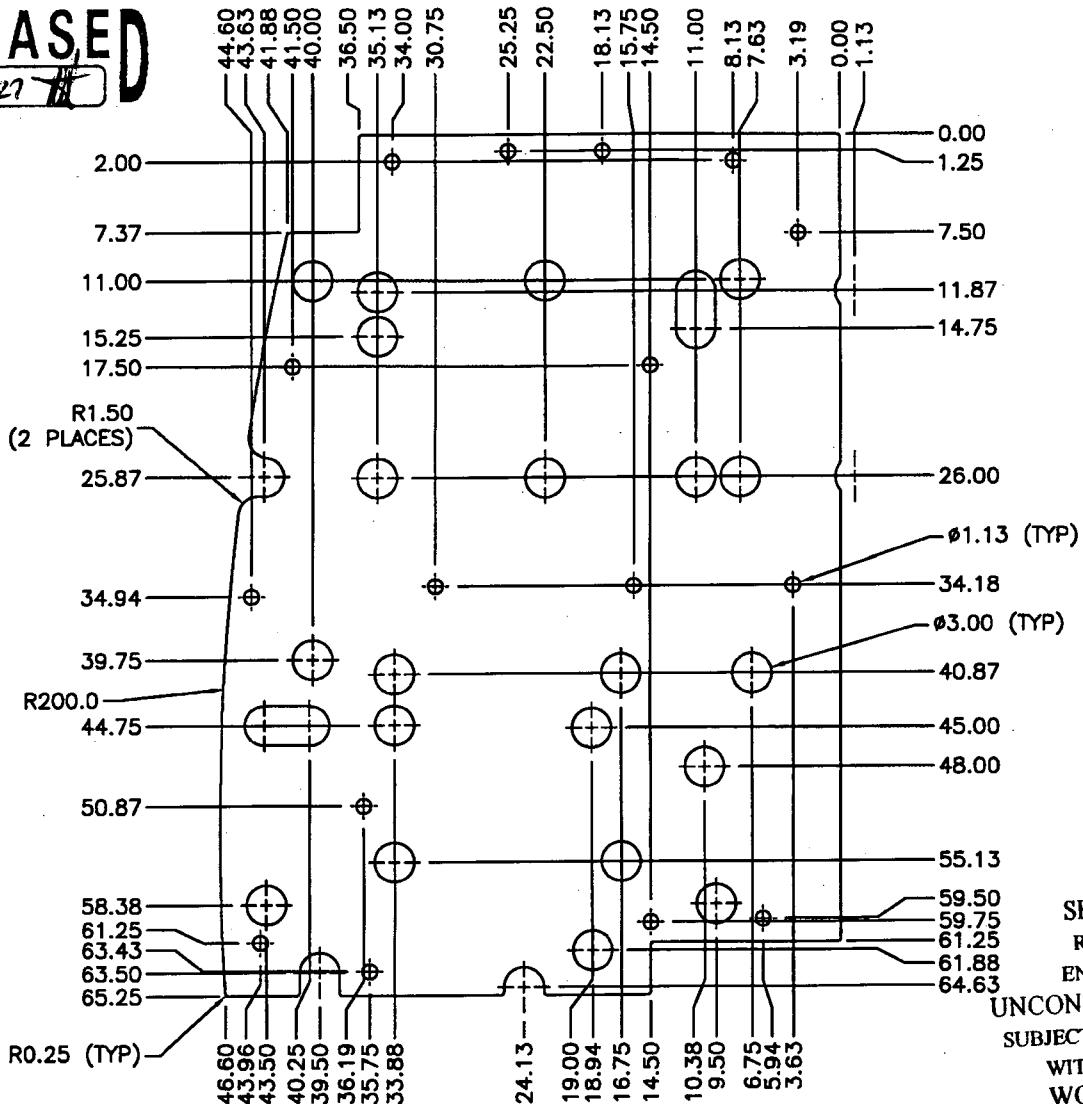
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

**Copyright © 2007 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TT</i>	DRAWING NO. D3574	REV. A SHEET 2 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.08**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

**Copyright © 2007 by DART AEROSPACE LTD**

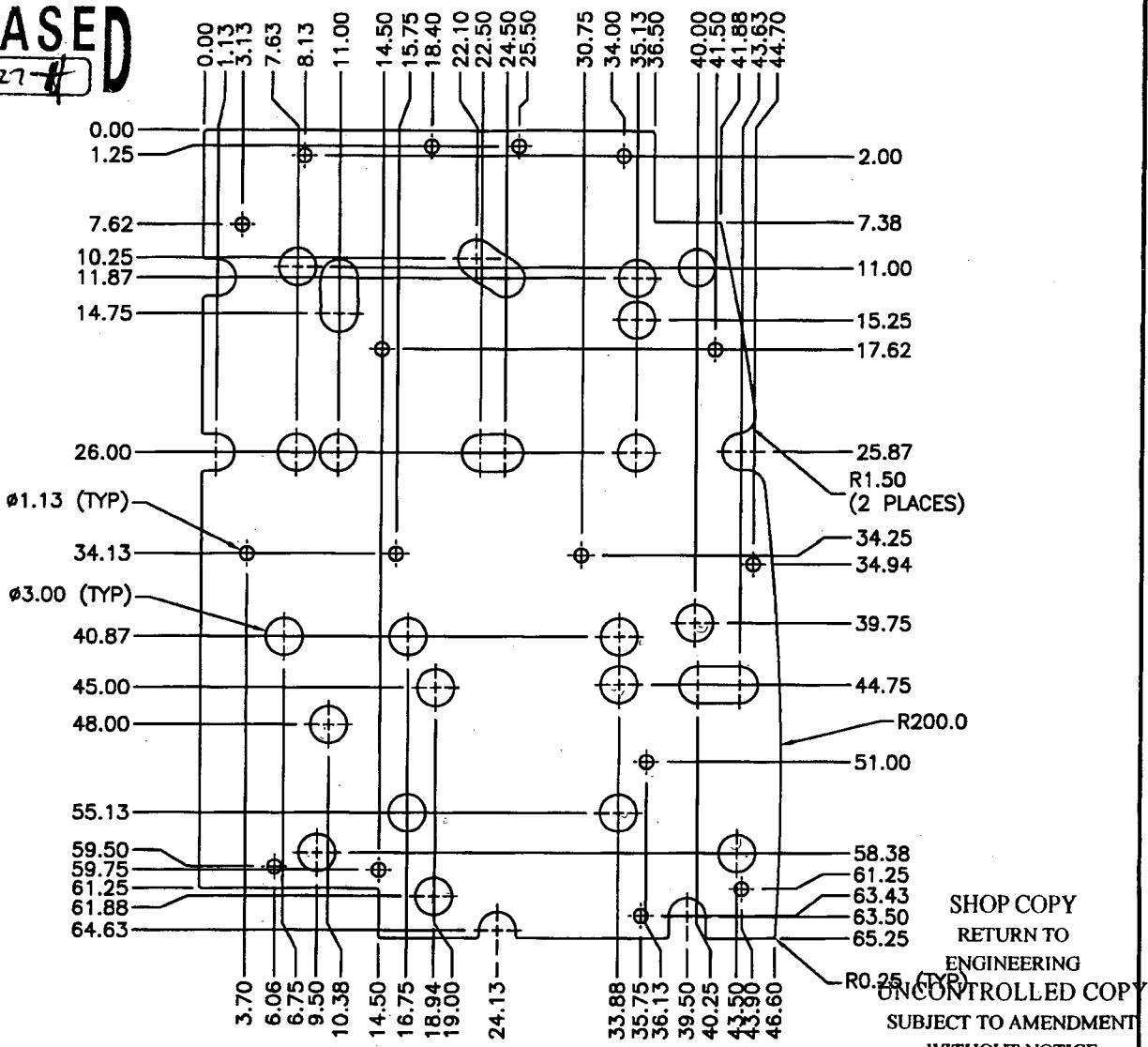
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# **DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3574	REV. A	SHEET 3 OF 5
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE	1:14

RELEASED  
07/06/27

07.06.27-#



**D3574-4 CABIN FLOOR PROTECTOR**

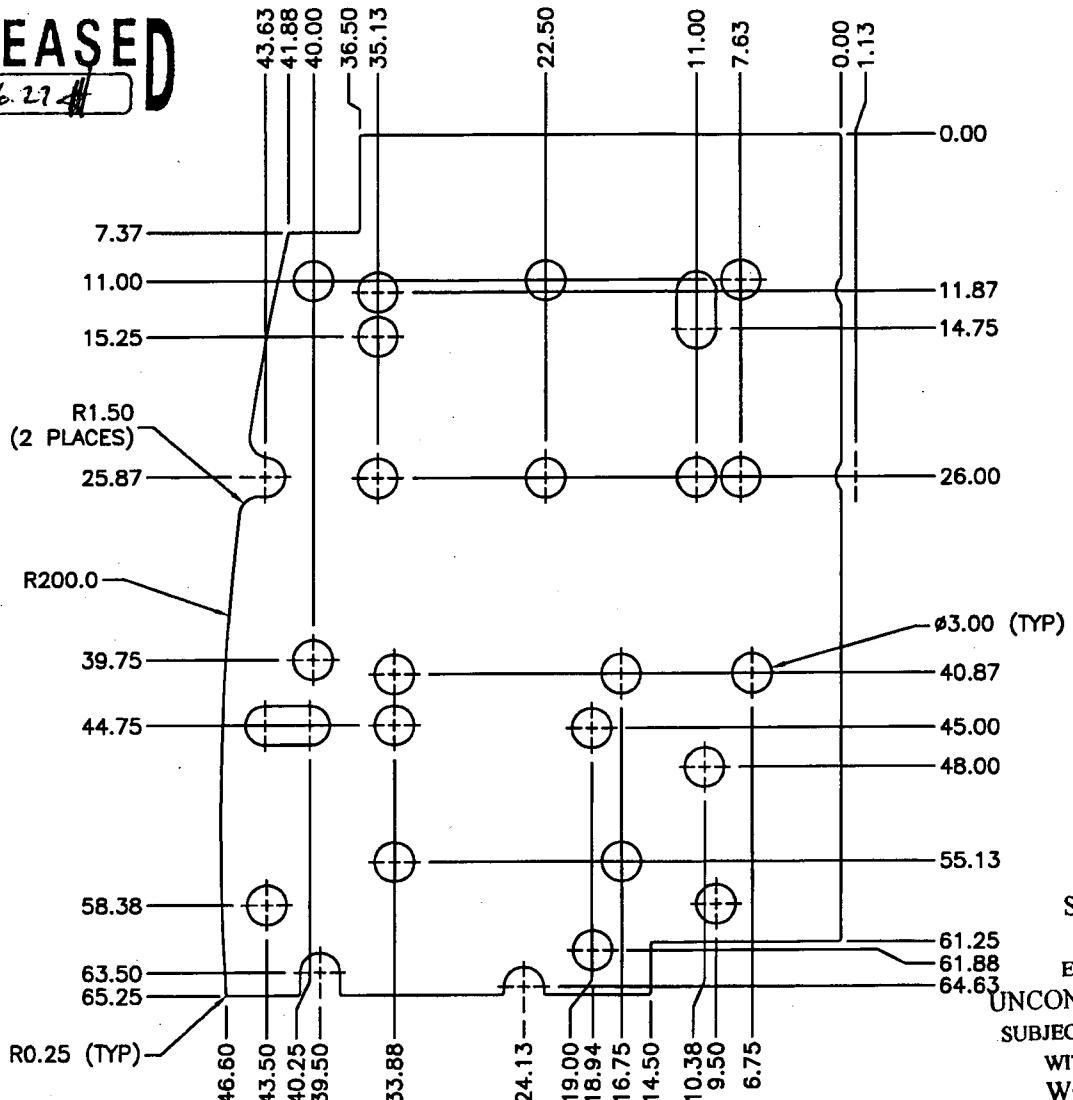
## NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

43      SHOP COPY  
50      RETURN TO  
25      ENGINEERING  
5      UNCONTROLLED COPY  
SUSPECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4064

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>ff</i>	DRAWING NO. D3574
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR

REV. A  
SHEET 4 OF 5  
SCALE  
1:14**RELEASED**  
07.06.27 *ff***D3574-5 CABIN FLOOR PROTECTOR**NOTES:

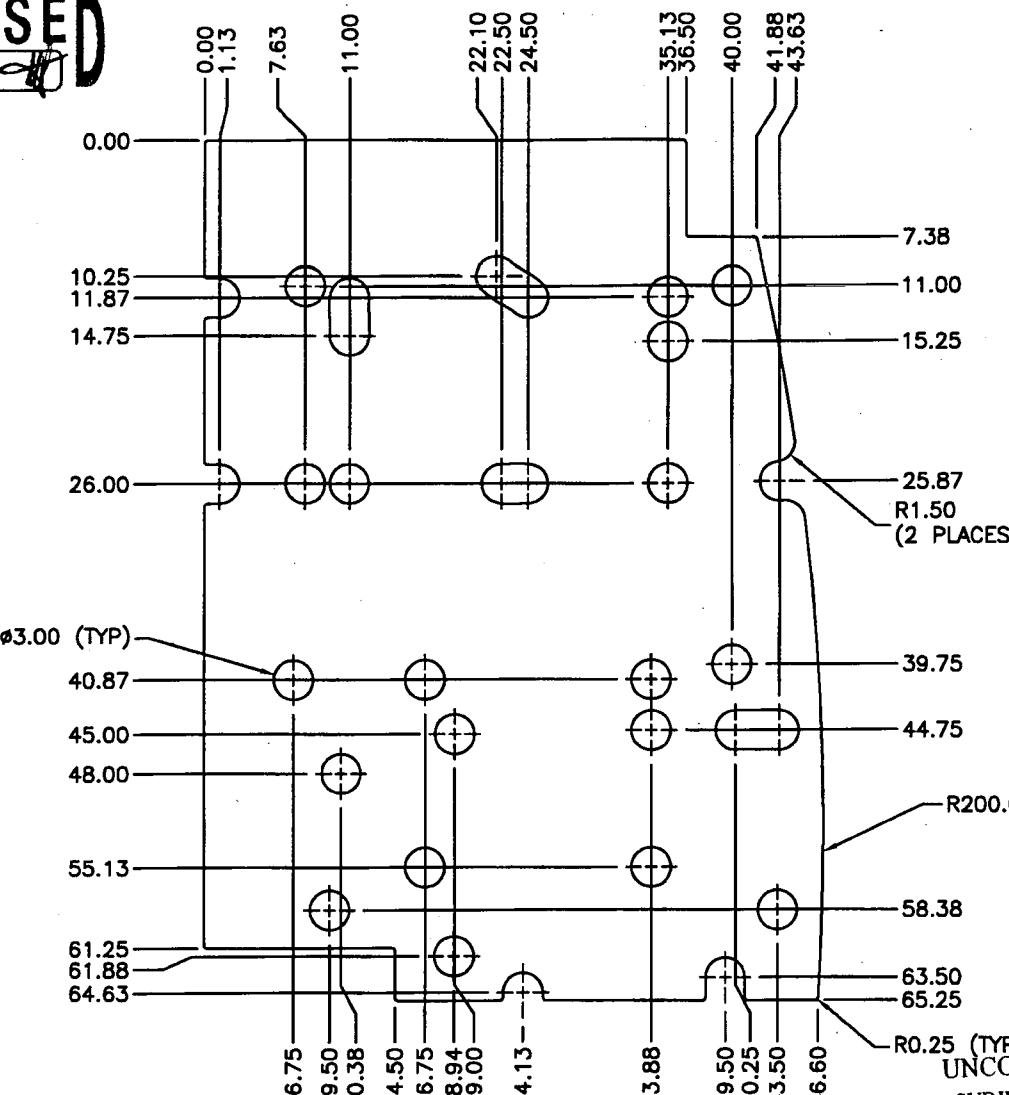
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.08

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *10647*

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

**Copyright © 2007 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.